



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D5122-1
Job Sheet 182315



Part No: D5122-1

Job Qty: 4 ea

Part Name: Center Support, Upper



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/22/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEETS 1,2 IPP REV.A NEW ISSUE JFS 14/07/16 VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Machining-3		SB L 18/09/15
100	CNC Vertical Machining	4 pcs	9/7/18	9/7/18	0.65	7.27	HAAS1-4		SB L 18/09/15
110	QC	4 pcs	9/7/18	9/7/18	0.00	0.00	QC2 Machining-3		SB L 18/09/15
120	QC	4 pcs	9/7/18	9/7/18	0.00	0.00	QC8 Machining-3		A.P 18-10-21
130	Packaging	4 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-2	LG053	AB 18-10-21
140	QC21-SA	4 Ea	9/7/18	9/7/18	0.00	0.00	QC21		

Part Op 100 - Machine as per Folio FB324
Descriptions: 130 - LOCATION : LG054

DAS
21 OCT 22 2018
9-59

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5122-1TRN	Center Support, Upper, Turning Detail	2 Ea (.5 ea)	90-Start up Operation	F165 332

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5122-1TRN	2	2	0

Part Specifications

Specifications could not be found.

Plex 8/22/18 12:56 PM Dart.lajeunesse.marie



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Container No: S110364



Part: D5122-1

Job No: 182315

Serial No/Batch: S110364

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/15/18

DART AEROSPACE LTD		Work Order: 182315
Description: Center Support		Part Number: D5122-1
Inspection Dwg: D5122	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	1.782	1.202		1.188	1.192	1.191	1.189	
AB	0.090	0.110		.098	.099	.100	.099	
AC	0.545	0.565		.553	.555	.553	.560	
AD	3.690	3.700		3.693	3.694	3.699	3.699	
AE	3.550	3.560		3.553	3.554	3.599	3.559	
AF	2.453	2.473		2.460	2.459	2.460	2.461	
AG	1.261	1.281		1.271	1.270	1.271	1.271	
AH	0.150	0.210		.185	.180	.195	.190	
AI	0.454	0.474		.464	.468	.462	.467	
AJ	Ø0.260	Ø0.267		.261	.261	.261	.261	
AK	Ø0.188	Ø0.194		.189	.189	.189	.189	
AL	3.067	3.077		3.072	3.072	3.072	3.072	
AM	3.990	4.010		4.000	4.001	4.000	4.000	
AN	1.990	2.010		1.995	2.002	2.002	2.003	
AO	Ø0.625	Ø0.630		.626	.626	.626	.626	
AP								
AQ								
AR								
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								

Ensure that Ø0.625" bore is perpendicular to Ø0.004" bore within R.1614

Accept/Reject 0.004 0.004 .003 .003

Measured by:

DAS
57
9-89

Date: 18/09/16

Audited by:

A-e

Date: 18-10-21

Preliminary Approval:

Date:

Rev	Date	Change	Revised By	Approved
A	15.03.12	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								